

20/05 12test

Dart Aerospace Ltd.


Date: Thursday, 01/05/2008 4:16:37 PM
User: Julie Lecocq



4

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 38969		
Estimate Number	: 10420		
P.O. Number	:	Part Number	: D3303043
This Issue	: 01/05/2008 S.O. No. :	Drawing Number	: D3303 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 38968	Material	:
Written By	:	Due Date	: 16/05/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JVO 08.5.02</u>		
Comment	: Est: A 04.09.07 New Issue KJ/JLM		

Additional Product

Job Number: 



Seq. #:	Machine Or Operation:	Description :
1.0	D33031	Plate
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) PLATE 10		
Pick:		
Qty	Part Number	Description Batch
1	D3303-1	Plate 38998

AS 08/05/14 (x10)



2.0	D33033	Bracket
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) BRACKET 10		
Pick:		
Qty	Part Number	Description Batch
1	D3303-3	Bracket 038972 x10

New Batch

AS 08/05/14 (x10)

3.0	MS20426AD33	Rivet
		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s) RIVET 72 + 8		
Pick:		
Qty	Part Number	Description Batch
8	MS20426AD3-3	Rivet M1563

AS 08/05/14 (x10)

4.0	MS20470AD44	Rivet, Universal Head
		
Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s) Rivet, Universal Head 144 + 16		
Pick:		
Qty	Part Number	Description Batch
		M107823

AS 08/05/14 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 38969

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

4 MS21075L3

Nut Plate

M107279

JS 08/05/14 (x10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

M 08/05/15 x10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/15 (x10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20 Pm

320 °F

2:50 Pm

M-L 08/05/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/05/21 (10x)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 188

JS 08/05/21 x10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-043 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/05/20
 QA: N/C Closed: _____ Date: _____

NCR: <u>38969</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/20	B.0	Prior to Paint it was found that one of the nut plates MS MS21075L3 has no threads R.C. Supplier of MS21075L3 only 1 part affected		Disassemble by drilling out all rivets and remove faulty at nut plate.	SB 08/05/20			
				Re assemble if needed	SB 08/05/20			08/05/20
				Rivet new MS MS21075LB B& M 107299 (62) MS20426 AD3-3 Rivet B& M 1563 (62)				
				Reinstall Rivets				08/05/20
				MS20470 AD44 B& M 107823 (X16)				08/05/20

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:37 PM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 38969

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

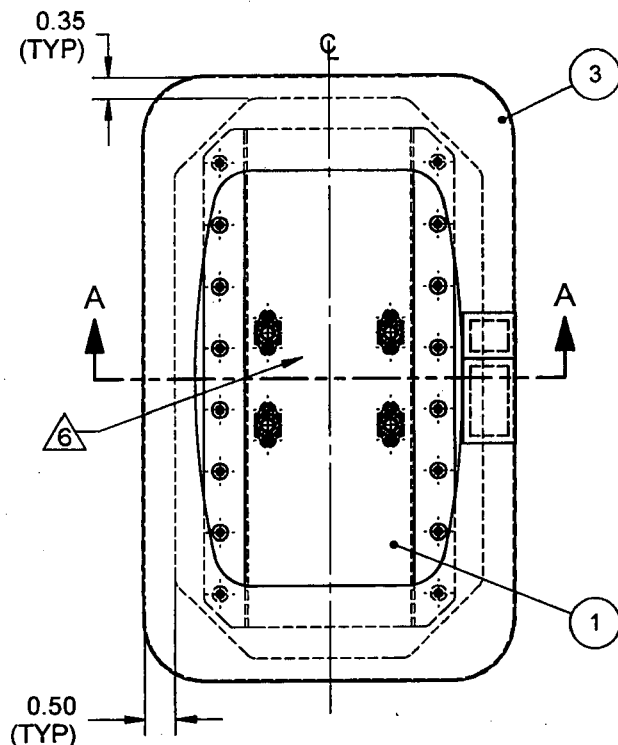
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

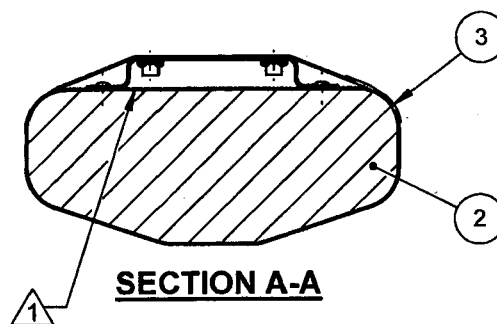
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

06-09-19 *[Signature]***SECTION A-A****D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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38969

NOTES:

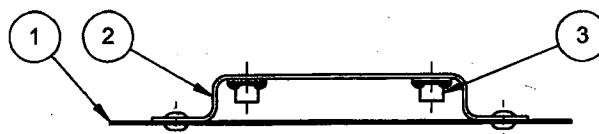
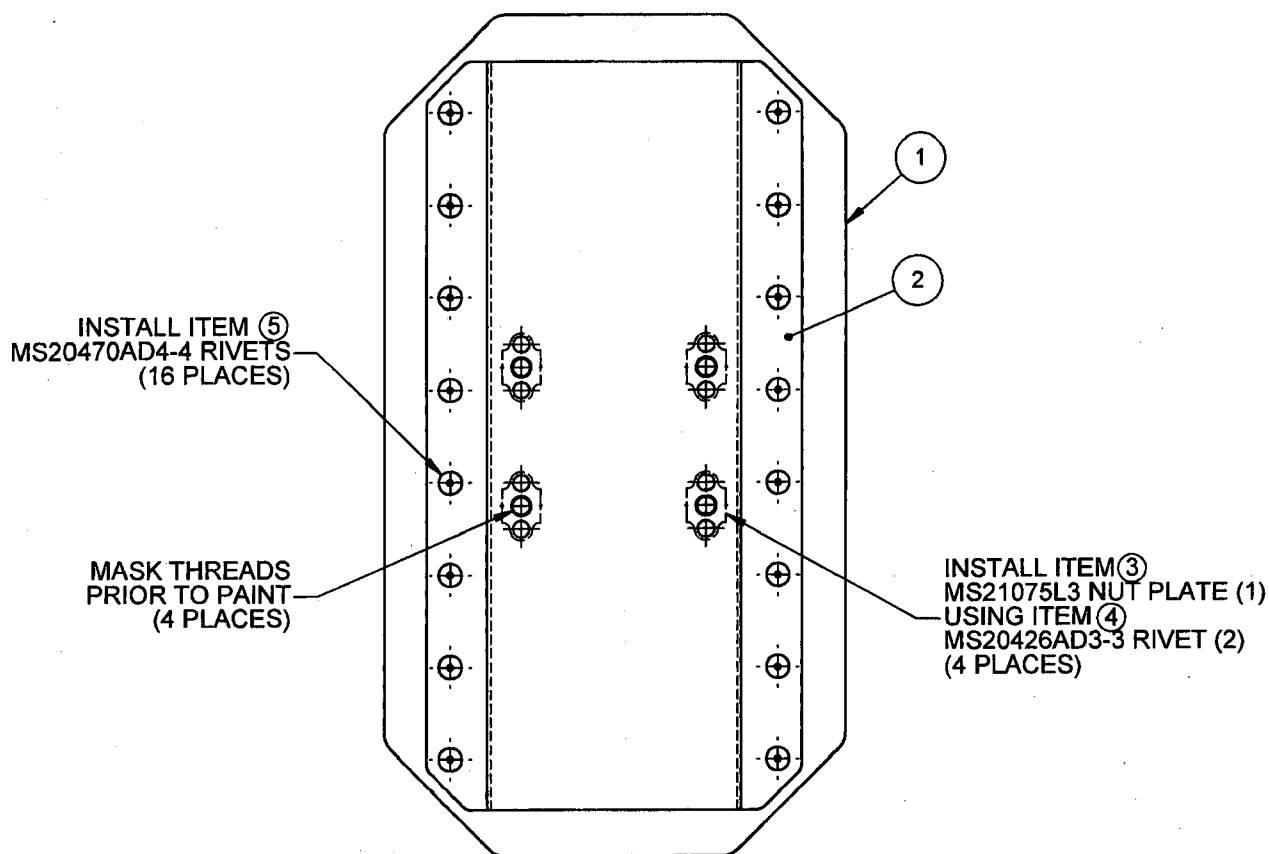
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED
06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

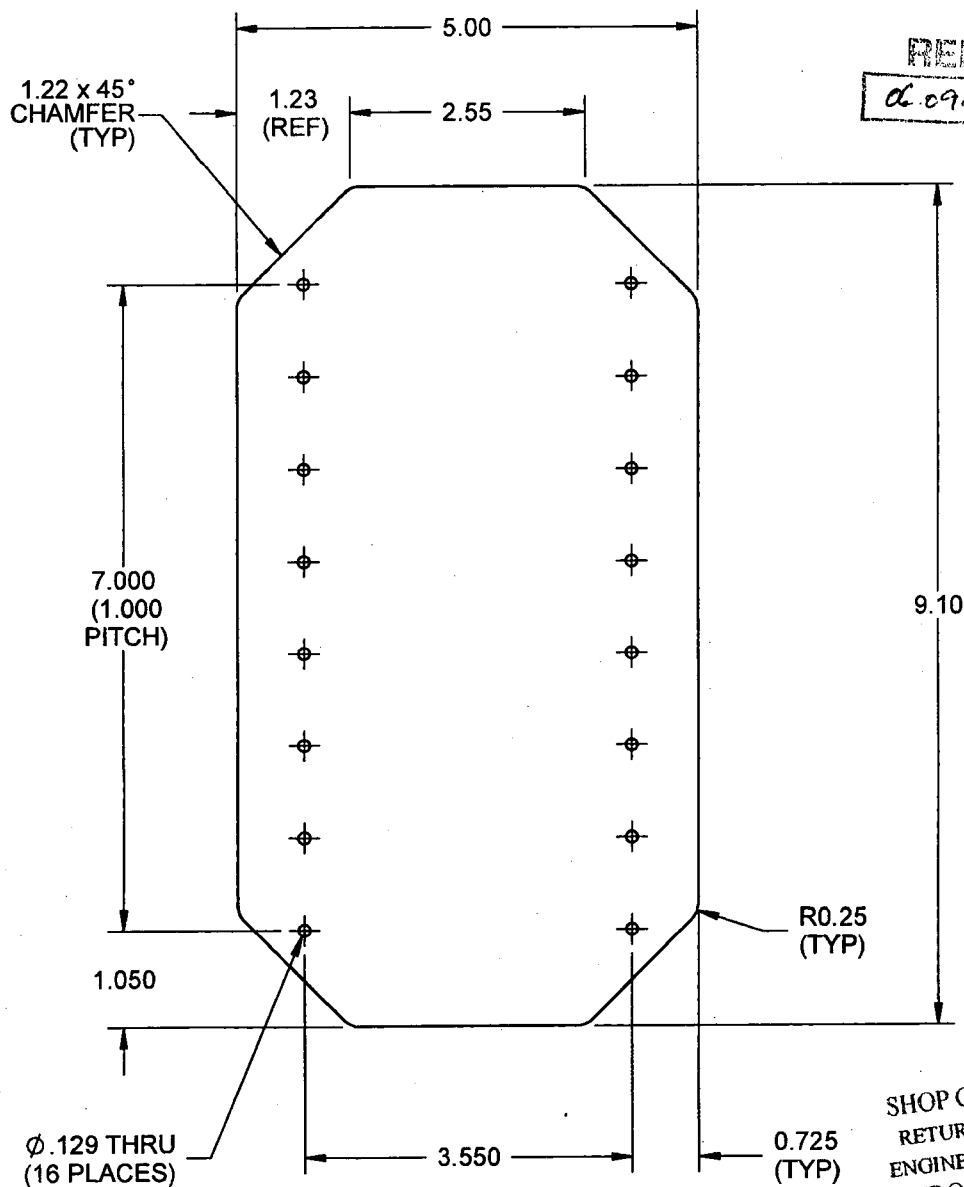
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

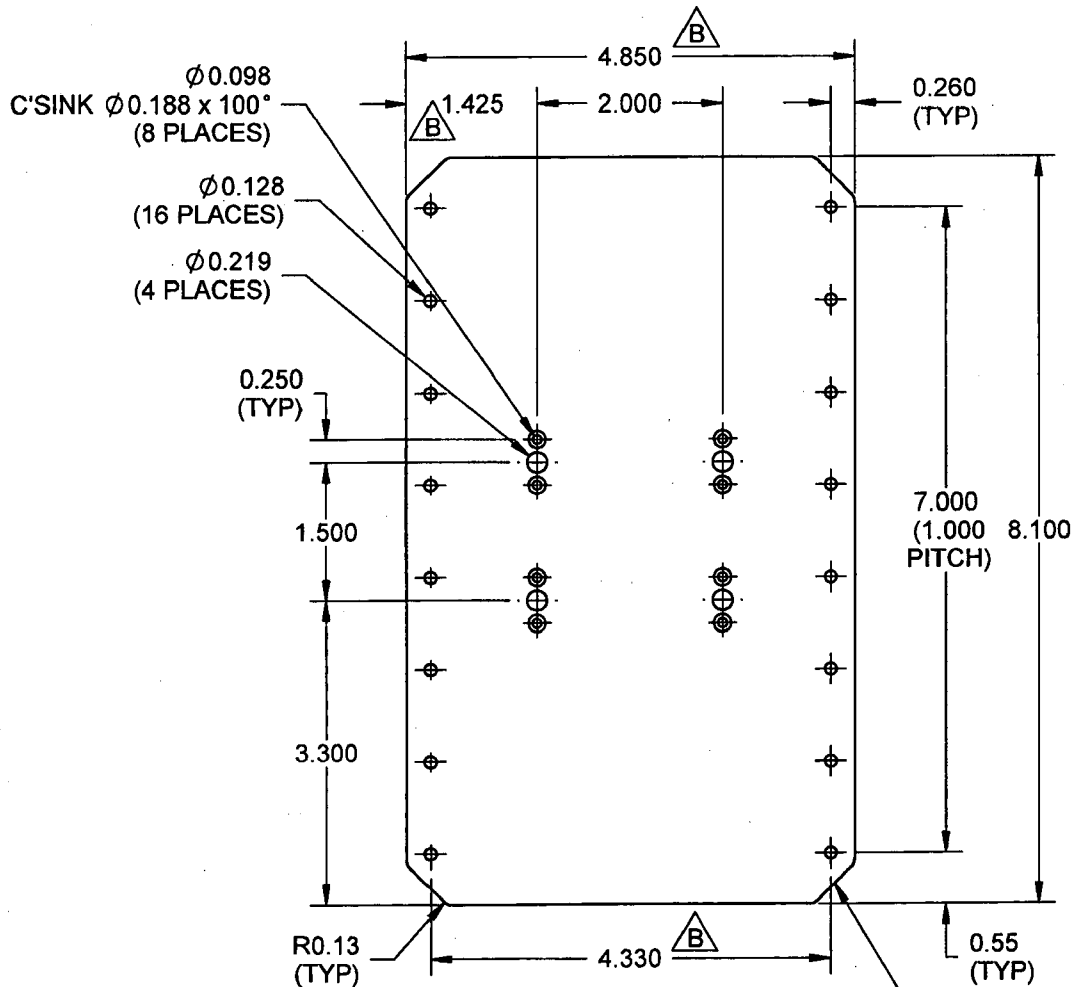
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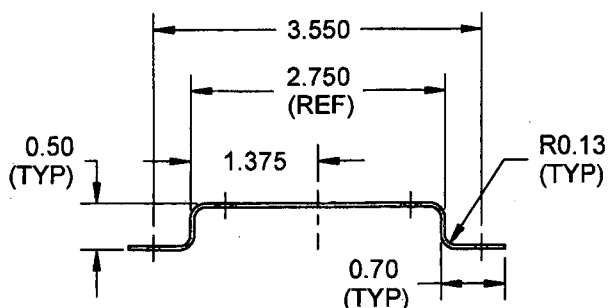
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CHECKED <i>PH</i>	APPROVED <i>B</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-3F BRACKET FLAT PATTERN

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06.09.19

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D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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